
वस्त्रादि — खादी के ऊनी और
ऊन/पॉलीएमाइड मिश्रित
कम्बल — विशिष्टि

(दूसरा पुनरीक्षण)

**Textiles — Blankets, Wool and
Wool/Polyamide *Khadi* —
Specification**

(*Second Revision*)

ICS 59.080.30

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FOREWORD

This Indian Standard (Second Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by the Handloom and *Khadi* Sectional Committee had been approved by the Textiles Division Council.

Blanket is a large piece of woollen or similar material that is put on beds, couches or elsewhere to provide warmth.

Woollen *khadi* blankets are used to provide added warmth whereas wool/polyamide *khadi* blankets are used due to its right combination of characteristics such as warmth, durability, ease-of-care, flexibility, and comfort.

This standard was originally published in 1968 and was revised in 1994. The standard has again been revised to incorporate the following major changes:

- a) Title of the standard has been modified;
- b) New variety of *khadi* blanket of 80/20 blend of wool/polyamide has been incorporated;
- c) Method of test for count of yarn along with its tolerance has been specified;
- d) Test method for identification of material has been incorporated;
- e) Requirement of relaxation shrinkage for blankets has been incorporated;
- f) Requirement of pilling for blankets has been incorporated;
- g) Sampling plan has been updated;
- h) References to Indian Standards have been updated; and
- a) BIS certification marking clause has been modified.

The composition of the Committee responsible for the formulation of this standard is given in Annex F.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 2022 'Rules for rounding off numerical values (*second revision*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

Indian Standard

TEXTILES — BLANKETS, WOOL AND WOOL/POLYAMIDE *KHADI* — SPECIFICATION

(*Second Revision*)**1 SCOPE**

1.1 This standard prescribes constructional particulars and other requirements for six varieties of *khadi* blankets.

1.2 This standard does not specify the general appearance, feel, finish, shade, etc of the blankets.

2 REFERENCES

The standards listed in Annex A contain provisions which, through reference in this text, constitute provisions of this standard. At the time of publication, the editions indicated were valid. All standards are subject to revision and parties to agreements based on this standard are encouraged to investigate the possibility of applying the most recent edition of these standards.

3 ATMOSPHERIC CONDITIONS FOR TESTING

Test specimens may be conditioned and tested in the prevailing atmospheric conditions for determining the conformity of blankets to the standard. However, in cast of dispute, the specimens shall be conditioned and tested in the standard atmosphere as specified in the referred Indian Standards on test methods.

4 MANUFACTURE**4.1 Yarn**

The woollen and wool/polyamide blended yarn used in the manufacture of blankets shall be hand spun from suitable quality. The approximate count of the warp and weft yarn is given in Table 1 for guidance.

NOTE — For production of blankets, superior, brick-red, wool *khadi* conforming to Variety No. 1 meant for defence supply 56s/60s quality wool may be used.

4.2 Blankets

4.2.1 The blankets shall be woven in 2/2 twill weave.

4.2.2 The blankets shall be either plain dyed or in check pattern as agreed to between the buyer and the seller.

4.2.3 The blankets shall be milled and raised.

4.2.4 The finished blankets shall be free from grease, soap or any other admixture which may give fictitious weight or firmness.

4.2.5 If required by the buyer, the blankets shall be mothproofed (*see* IS 11662).

4.2.6 The transverse ends of blankets shall have either piping with 6 mm turn-in or cut down and whipped or finished with a fringe as agreed to between the buyer and the seller.

5 REQUIREMENTS

5.1 The constructional particulars of the blankets shall conform to the requirements specified in Table 1.

5.2 The blankets shall also conform to the other requirements specified in Table 2.

5.3 Dimensions

5.3.1 Length and width of the *khadi* blankets, when determined in accordance with IS 1954, shall be as agreed to between the buyer and the seller or as declared by the seller subject to the tolerances notified in the Government of India, Ministry of Commerce and Industry Notification No. SO. 2937 dated 20 September 1962 issued under *Trade and Merchandise Marks Act*, 1958 (43 of 1958) (*see* Annex D).

NOTE — Generally the size of the blankets is as follows:

Plain dyed	250 cm × 150 cm
Check	240 cm × 135 cm
Superior, brick-red	230 cm × 152 cm

5.4 Freedom from Defects

The blankets when visually inspected shall be free from the major flaws listed at Annex E. However, the number of permissible flaws per piece may be as agreed to between the buyer and the seller.

5.5 Sealed Sample

5.5.1 In order to illustrate or specify the indeterminable characteristics, such as general appearance, feel, shade, etc, if a sample has been agreed upon and sealed, the supply shall also be in conformity with the sample in such respects.

5.5.2 The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

Table 1 Constructional Particulars of Blankets*(Clauses 4.1 and 5.1)*

Sl No.	Variety No.	Count of Yarn (for Guidance only) Universal Count (Woollen Count)		Ends/dm	Picks/dm	Mass g/m ²
		Warp	Weft			
(1)	(2)	(3)	(4)	(5)	(6)	(7)
i)	1	125 tex × 2 (16s/2)	125 tex (16s)	95	80 Double	560
ii)	2	250 tex × 2 (8s/2)	250 tex (8s)	48	40 Double	500
iii)	3	250 tex × 2 (8s/2)	330 tex (6s)	55	40 Double	610
iv)	4	200 tex × 2 (10s/2)	250 tex (8s)	65	50 Double	610
v)	5	200 tex × 2 (10s/2)	200 tex (10s)	75	55 Double	560
vi)	6 (see Note 2)	240 tex (8.1s)	240 tex (8.1s)	120	90	685
Tolerance, percent	—	± 5	± 5	± 5	± 5	± 5
Method of Test, Ref to	—	IS 3442		IS 1963		IS 1964 or Annex B
NOTES						
1 Any increase in values of ends/dm, picks/dm or mass (g/m ²) beyond positive tolerance shall not be a cause of rejection of the blankets.						
2 Variety No. 6 is <i>khadi</i> blanket of 80/20 blend of wool/polyamide.						

Table 2 Other Requirements for Blankets

(Clause 5.2)

Sl No.	Characteristics	Requirement	Method of Test, Ref to
(1)	(2)	(3)	(4)
i)	Dimensional changes, percent, <i>Max</i> Relaxation shrinkage, percent, <i>Max</i>	2 5	IS 665
ii)	pH value of the aqueous extract	5.0 to 7.5	IS 1390
iii)	Colour fastness (for dyed fabrics only): a) Light b) Washing Test(1): 1) Change in colour 2) Staining on fabric a) Organic solvent: 1) Change in colour 2) Staining on fabric b) Rubbing: 1) Change in colour 2) Staining on fabric c) Perspiration: 1) Change in colour 2) Staining on fabric	5 or better 3 or better 3 or better 3 or better 3 or better 3 or better 3 or better 3 or better 3 or better	IS/ISO 105-B01 or IS/ISO 105-B02 IS/ISO 105-C10 IS/ISO 105-X05 IS/ISO 105-X12 IS/ISO 105-E04
iv)	Scouring loss, percent, <i>Max</i>	4	Annex C
v)	Pilling rating	3 or better	IS 10971 (Part 1)
vi)	a) Fibre composition, <i>Min</i> (for Variety No. 1 to Variety No. 5 only) b) Fibre composition (for Variety No. 6 only) 1) Wool 2) Polyamide	97 percent wool 80 percent \pm 2 percent 20 percent \pm 2 percent	IS 2006 IS 2006

6 SAMPLING**6.1 Lot**

The number of blankets delivered to one buyer against one despatch note shall constitute a lot.

6.2 The conformity of the lot to the various requirements specified in the standard shall be

determined on the basis of tests carried out on the samples selected from the lot.

6.3 Unless otherwise agreed, the number of pieces selected at random for inspection shall be in accordance with Table 3.

6.3.1 For selection of samples at random from the lot, procedure given in IS 4905 may be followed.

Table 3 Sample Size and Permissible Number of Non-conforming Pieces*(Clause 6.3)*

Sl No.	Lot Size	Sample Size	Permissible Number of Non-conforming Pieces	Sub-sample Size
(1)	(2)	(3)	(4)	(5)
i)	Up to 90	5	0	3
ii)	91 to 150	8	0	3
iii)	151 to 500	13	1	5
iv)	501 to 1 200	20	1	5
v)	1 201 to 10 000	32	2	8
vi)	10 001 to 35 000	50	3	8
vii)	35 001 to 500 000	80	5	13
viii)	500 001 and above	125	7	13

6.4 Number of Samples and Criteria for Conformity

The number of samples to be drawn and the criteria for conformity of the material for various characteristics shall be as follows:

Sl No.	Characteristics	Number of Samples	Criteria for Conformity
(1)	(2)	(3)	(4)
i)	Ends, picks, mass, length, width and freedom from defects	According to col (2) of Table 3	Number of nonconforming pieces shall not exceed the corresponding number given in col (3) of Table 3
ii)	Dimensional changes, scouring loss, pH value, colour fastness and fibre composition	According to col (4) of Table 3	All the test pieces shall meet the requirements

7 MARKING

7.1 The blankets shall be suitably marked with the following information:

- Name of the material and variety number;
- Length (cm) and width (cm);
- GSM (g/m²);
- Indication of the source of manufacture; and
- Any other declarations required as per law in force.

7.2 BIS Certification Marking

The blanket(s) conforming to the requirements of

this standard may be certified as per the conformity assessment schemes under the provisions of the *Bureau of Indian Standards Act, 2016* and the Rules and Regulations framed thereunder, and the products may be marked with the Standard Mark.

8 PACKING

Unless otherwise agreed upon by the buyer and the seller, the blankets shall preferably be packed in bales or cases in conformity with the procedure laid down in IS 32 or IS 741.

ANNEX A

(Clause 2)

LIST OF REFERRED STANDARDS

<i>IS No.</i>	<i>Title</i>	<i>IS No.</i>	<i>Title</i>
IS 293 : 1980	Code for seaworthy packaging of cotton yarn and cloth (<i>third revision</i>)		removed from fabric (<i>second revision</i>)
IS 665 : 1989	Textiles — Determination of dimensional changes of fabrics containing wool on soaking in water (<i>first revision</i>)	IS 4905 : 2015/ ISO 24153 : 2009	Random sampling and randomization procedures (<i>first revision</i>)
IS 667 : 1981	Methods for identification of textile fibres (<i>first revision</i>)	IS 10971 (Part 1) : 2022/ISO 12945 -1 : 2020	Textiles — Determination of fabric propensity to surface pilling, fuzzing or matting: Part 1 Pilling box method (<i>second revision</i>)
IS 741 : 1971	Code for inland packaging of woollen and worsted yarn and cloth (<i>first revision</i>)	IS 11662 : 1986	Specification for preservative treatments of textiles
IS 1390 : 2022/ ISO 3071 : 2020	Textiles — Determination of pH of aqueous extract (<i>third revision</i>)	IS/ISO 105-B01 : 2014	Textiles — Tests for colour fastness: Part B01 Colour fastness to light: Daylight
IS 1954 : 1990	Determination of length and width of woven fabrics — Methods (<i>second revision</i>)	IS/ISO 105-B02 : 2014	Textiles — Tests for colour fastness: Part B02 Colour fastness to artificial light: Xenon arc fading lamp test
IS 1963 : 1981	Methods for determination of threads per unit length in woven fabrics (<i>second revision</i>)	IS/ISO 105-C10 : 2006	Textiles — Tests for colour fastness: Part C10 Colour fastness to washing with soap or soap and soda
IS 1964 : 2001	Textiles — Methods for determination of mass per unit length and mass per unit area of fabrics (<i>second revision</i>)	IS/ISO 105-E04 : 2013	Textiles — Tests for colour fastness: Part E04 Colour fastness to perspiration
IS 3442 : 2023	Textiles — Method for determination of crimp and linear density of yarn	IS/ISO 105-X05 : 1994	Textiles — Tests for colour fastness: Part X05 Colour fastness to organic solvents
		IS/ISO 105-X12 : 2016	Textiles — Tests for colour fastness: Part X12 Colour fastness to rubbing (<i>first revision</i>)

ANNEX B

(Table 1)

METHOD FOR DETERMINATION OF MASS OF BLANKETS

B-1 Cut four specimens of 100 mm × 100 mm from a sample. Condition all the specimen in the desiccator charged with saturated solution of sodium nitrate at 27 °C ± 2 °C for a period of 24 hours. Remove all the specimens from the desiccator and

immediately determine their collective mass in weighing balance to the nearest milligram.

B-2 Calculate mass of blankets in g/m².

ANNEX C

(Table 2)

METHOD FOR DETERMINING SCOURING LOSS

C-1 TEST SPECIMEN

Take about 10 g of yarn from each sample. This shall constitute a test specimen.

C-2 PROCEDURE

Dry the test specimen to constant mass in the drying oven at 105 °C ± 3 °C temperature and determine its mass accurately.

NOTE — Constant mass shall be deemed to have been reached if the difference between the two successive weighing at an interval of 20 minute is less than 0.05 percent.

C-3 Extract the specimen with a mixture of benzene and methyl alcohol in the proportion of 3 : 2 in a soxhlet apparatus for 4 hours at the rate of 5 extractions per hour, taking care to place the

specimen in a thimble and covering it with cotton wool previously extracted with petroleum hydrocarbon solvent (Petroleum ether). Remove the specimen from the extract. Dry the residue to a constant mass (*see* Note under **C-2**) at 105 °C ± 3 °C and determine the mass accurately.

C-4 CALCULATION

Calculate the scouring loss by the following formula:

$$\text{Scouring loss, percent} = \frac{a}{b} \times 100$$

where

a = mass of the dry residue (*see* **C-3**); and

b = mass of the test specimen (*see* **C-2**).

ANNEX D

(Clause 5.3.1)

**EXTRACTS FROM THE GOVERNMENT OF INDIA, MINISTRY OF COMMERCE AND
INDUSTRY (TRADE AND MERCHANDISE MARKS) NOTIFICATION NO. S.O. 2937,
DATED 20 SEPTEMBER 1962**

D-1 A trade description of length and width on woollen (including shoddy) and worsted fabricated items like blankets, shawls, scarves or other articles of a similar kind:

- a) The actual length of the piece shall not be less than stamped length by more than 1 percent; and
- b) The permissible limits of variation in respect of trade description of width shall be as those prescribed for width of woollen and worsted price goods (*see* **D-2**).

D-2 A trade description of width stamped on worsted,

woollen and shoddy piece goods:

- a) In pieces of worsted fabric the stamped width shall not be greater or less than the actual width provided that the variation in width at any point is not more than 2 percent and on average not more than 1.5 percent; and
- b) In pieces of woollen and shoddy piece goods, the stamped width shall not be greater or less than the actual width, provided that the variation in width at any point is not more than 3 percent and on average not more than 2 percent.

ANNEX E*(Clause 5.4)***LIST OF MAJOR FLAWS**

- | | |
|--|--|
| <ul style="list-style-type: none"> a) More than one adjacent end missing in the body of the material running throughout the piece or more than three ends missing at a place and running over 2.5 cm or prominently noticeable double end running throughout the piece; b) Undressed snarls noticeable over a length exceeding 5 percent of the length of the piece; c) Smash definitely rupturing the texture of the fabric; d) Hole, cut or tear other than pin holes; e) Cockled finish causing defective appearance in in texture of fabric; f) Prominent mill rigs such as felted folds and crease produced during milling; g) Prominent water marks all over the cloth; h) Weft crack of two or more missing picks across the width of the fabric; j) Weft bar due to the difference in raw material, count, twist, lustre, colour, shade or pick spacing of adjacent groups of weft yarns (starting mark); k) More than two adjacent ends running parallel, broken or missing and extending beyond 10 cm; | <ul style="list-style-type: none"> m) Noticeable warp or weft float in the body of the fabric; n) Noticeable oil or other stain in the fabric; p) Oily weft in the fabric; q) Prominently noticeable slub or slubby Weft or foreign matter such as blur, twigs, leaves, straw, etc; r) Conspicuous broken pattern; s) Prominently visible knot of warp or weft yarn tied into having hard projection; t) Prominent selvedge defect; u) Significant shading or listing in fabrics having a gradual change in tone or depth of shade of fabric (excluding selvedge or border running parallel to the selvedge); v) Prominently noticeable dyeing defects such as patchy, streaky or uneven dying; w) Milling and scouring defects such as excess or deficiency of cover due to difference in milling, scouring or raising; and y) Pilling or defective raising. |
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ANNEX F

(Foreword)

COMMITTEE COMPOSITION

Handloom and *Khadi* Sectional Committee, TXD 08

<i>Organization</i>	<i>Representative(s)</i>
Weavers Service Centre, Delhi	SHRI VISHESH NAUTIYAL (<i>Chairperson</i>) SHRI VIKAS KUMAR (<i>Alternate</i>)
Baster Adimjati Sewak Sangh, Baster	SHRI SUMIT DAS SHRI AMIT DAS (<i>Alternate</i>)
Central Pollution Control Board, New Delhi	SHRI P. K. MISHRA SHRI RISHABH SRIVASTAV (<i>Alternate</i>)
Central Reserve Police Force, New Delhi	SHRI D. P. UPADHYAY SHRI SANJEEV KUMAR SINGH (<i>Alternate</i>)
Department of Handlooms & Textiles, Chennai	SHRI T. P. RAJESH DR K. KARNAN (<i>Alternate</i>)
Gandhigram Rural Institute, Dindigul	REPRESENTATIVE
Haryana Khadi Gramodyog Sangh, Karnal	SHRI PAWAN GARG SHRI R. S. YADAV (<i>Alternate</i>)
ICAR – Central Institute for Research on Cotton Technology, Mumbai	DR SUJATA SAXENA DR A. S. M. RAJA (<i>Alternate</i>)
Indian Institute of Handloom Technology, Varanasi	DR P. THENNARASU
Indian Institute of Handloom Technology, Jodhpur	DR J. SIVAGNANAM
Indo Tibetan Border Police, New Delhi	SHRI UTTAM KUMAR SHRI ANAND KUMAR (<i>Alternate</i>)
Jan Sewa Ashram, Aligarh	SHRI R. K. SHARMA SHRI AKHILESH KUMAR AWASTHI (<i>Alternate</i>)
Karnatka Khadi Gramodyog Samyuktha Sangha, Hubli	SHRI K. V. PATTAR SHRI SHIVANANDA S. (<i>Alternate</i>)
Khadi & Village Industries Commission, New Delhi	SHRI P. NALLAMUTHU SHRI RAM NARAYAN (<i>Alternate</i>)
Khadi Dyers & Printers, Mumbai	SHRI D. N. BHATT SHRI V. D. JOSHI (<i>Alternate</i>)
Khadi Gramodyog Mandal, Rampur	SHRI RAKESH CHAUDHARY SHRI PRINCE CHAUDHARY (<i>Alternate</i>)
Kshetriya Khadi Gramodyog Samiti, Dausa	SHRI R. K. SINGH
Madhya Bharat Khadi Sangh, Gwalior	SHRIMATI NEELU MEKLE SHRI HARISH MEKLE (<i>Alternate</i>)
Mahatma Gandhi Institute for Rural Industrialization, Wardha	REPRESENTATIVE

<i>Organization</i>	<i>Representative(s)</i>
Metpalli Khadi Gramodyog Pratisthan, Metpalli	SHRI G. MADHAV
Ministries of Defence (DGQA), New Delhi	SHRI ARVIND COMPATHANE SHRI N. SENTHIL KUMAR (<i>Alternate</i>)
Ministries of Health, New Delhi	REPRESENTATIVE
National Handloom Development Corporation Ltd, Gautam Budh Nagar	DR SAKTHIVEL PERUMALSAMY SHRI JITENDRA TOLAMBIYA (<i>Alternate</i>)
Northern Railways, New Delhi	SHRI SUDHANSHU KUMAR GUPTA
Northern India Textile Research Association, Ghaziabad	DR M. S. PARMAR SHRI SANJEEV SHUKLA (<i>Alternate</i>)
Office of The Development Commissioner for Handlooms, New Delhi	SHRI SIDDHARTH SINGH SHRI VINAY KUMAR (<i>Alternate</i>)
Rastriya Khadi Gramodyog Federation, Moradabad	SHRI ANIL KUMAR SINGH SHRI KULDEEP SINGH (<i>Alternate</i>)
Sushil Gramodyog Sanstha, Ghaziabad	SHRI SUNIL TYAGI
Swastik Gramodyog Samiti, Delhi	SHRI M. L. PATHAK SHRI ABHISHEK DIXIT (<i>Alternate</i>)
Textiles Committee, New Delhi	SHRI KARTIKAY DHANDA SHRIMATI SHILPI CHAUHAN (<i>Alternate</i>)
The Cotton Textiles Export Promotion Council (TEXPROCIL), Mumbai	DR SIDDHARTHA RAJAGOPAL SHRI RAJESH SATAM (<i>Alternate</i>)
The Handloom Export Promotion Council, Chennai	DR M. SUNDAR EXPORT PROMOTION OFFICER (<i>Alternate</i>)
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Member Secretary
SHRI SWAPNIL
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